

Date: Wednesday, 02/04/2008 3:35:42 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GUIDE		
Job Number	: 38324		Part Number	: D35723		
Estimate Number	: 12705		Drawing Number	: D3572 REV.C		
P.O. Number	:		Project Number	: N/A		
This Issue	: 02/04/2008	S.O. No. :	Drawing Revision	: C		
Prsh Rev.	: NC		Material	:		
First Issue	: / /	Type : MACHINED PARTS	Due Date	: 15/04/2008	Qty:	40
Previous Run	: 32172		Um:	Each		
Written By	: <i>JUL 08.04.07</i>					
Checked & Approved By	:					
Comment	: Est Rev.A New Issue 07-02-07 JLM est rev B rev.B dwg EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X01000	1.500" x .625" 6061-T6 Bar .50" x 1.0" <i>.625" This Batch only.</i> Comment: Qty.: 0.0893 f(s)/Unit Total: 3.5700 f(s) → 5 feet of <u>M107436</u> (Guaranteed) 6061-T6 Bar .50" X 1.00 1.500" x .625" 1.6 Sqt. Batch: <u>M101549</u> → 2 feet SD 08/04/07
2.0	BAND SAW	BAND SAW <i>20" = 1 ft</i> Comment: BAND SAW Cut blank 1.500" long. 500" <i>JUL 07.04.07</i> SD 08/04/07
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 <i>08/04/08</i> Comment: HAAS CNC VERTICAL MACHINING #1
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <i>08/04/08</i> Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>H.A./JUL 07</i> SD 08/04/07
5.0	QC8	SECOND CHECK <i>08.04.08</i> Comment: SECOND CHECK <i>EC 08.04.08</i> 40

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3572 - 3 PAR #: N/A Fault Category: Prod/Material Parts NCR: Yes No DQA: D Date: 08/04/15
(D412-702) QA: N/C Closed: D Date: 08/04/15

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/08	1,2	40 Blanks were cut in with the wrong grain direction.	<u>J</u> <u>0810412</u>	<u>Scrap and Discard</u> <u>Quarantine and Red Tag</u> <u>Take Blank in Box</u> <u>AND re-cut to Dwg. 3572</u>	<u>C</u> <u>08/04/08</u>	<u>JMK</u> <u>08/04/08</u>	<u>D</u> <u>0810412</u>	<u>0810412</u>
			<u>J</u> <u>0810412</u>	<u>Hire w/o to reflect file</u> <u>Grain direction for cutting</u> <u>Blanks</u>		<u>JMK</u> <u>08/04/08</u>	<u>D</u> <u>0810412</u>	<u>0810412</u>

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
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6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PACD

AS 08/04/09 X(4)

7.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-11

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	38324
Description: Guide		Part Number:	D3572-3
Inspection Dwg: D3572	Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

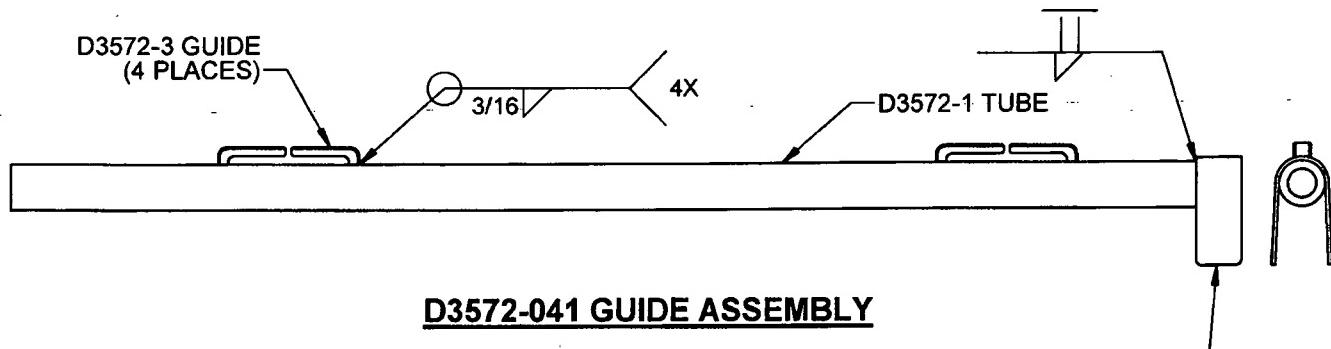
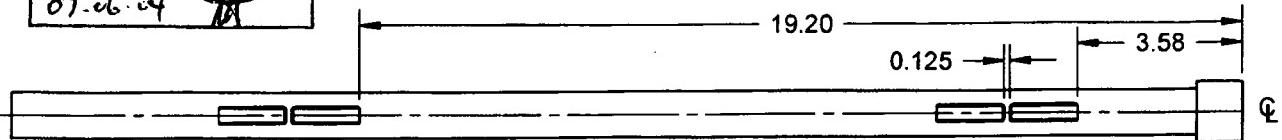
X First Article Prototype

Measured by:	<u>SD</u>	Audited by:	<u>LS</u>	Prototype Approval:	N/A
Date:	<u>08/04/07</u>	Date:	<u>08/04/07</u>	Date:	N/A

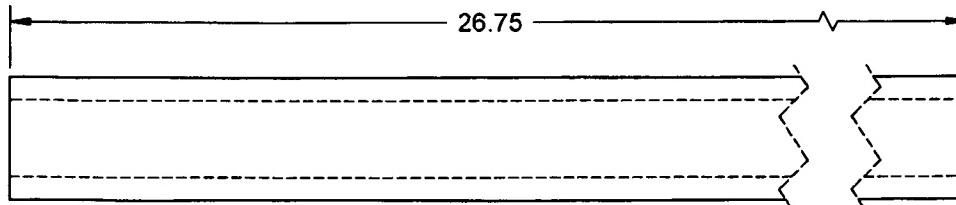
Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	<i>[Signature]</i>

DART

DESIGN <i>CG</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3572	REV. C	SHEET 1 OF 2
DATE 07.06.01		TITLE GUIDE ASSEMBLY	SCALE 1:4	

RELEASED07.06.04 *#***D3572-041 GUIDE ASSEMBLY****D3572-041 NOTES:**

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3572-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) WELD PER DART QSI 004

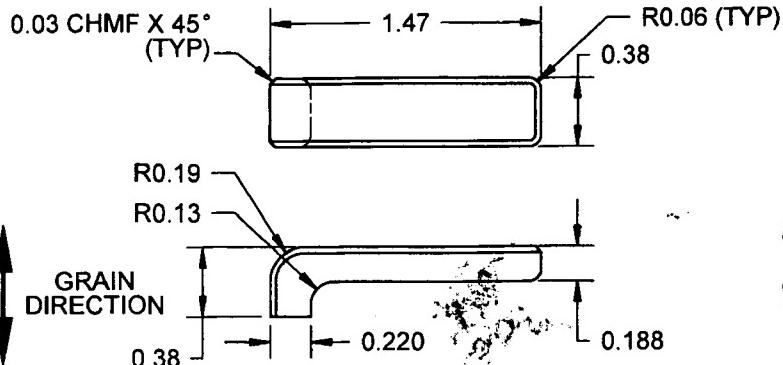
**D3572-1 TUBE****D3572-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
(REF DART SPEC M6061T6T1.000W.188)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

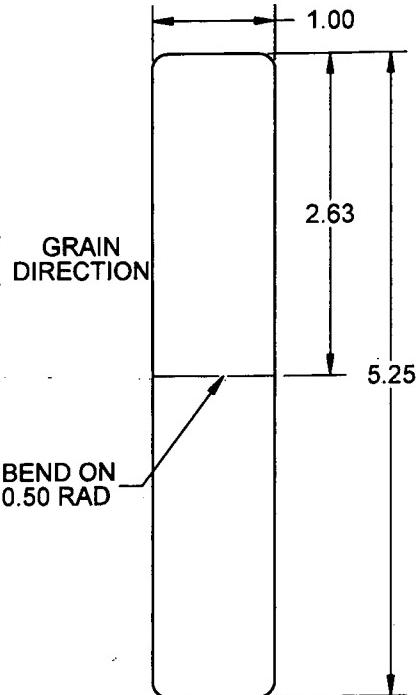
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WORK ORDER
NO 3832

DART

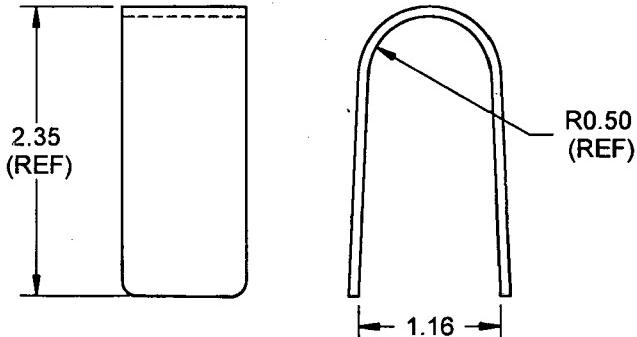
DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>AK</i>	DRAWING NO. D3572	REV. C SHEET 2 OF 2
DATE 07.06.01	TITLE GUIDE ASSEMBLY	SCALE 2:3	



1 **D3572-3 GUIDE**



2 **D3572-5F FLAT PATTERN**



**D3572-5 BRACKET
(MAKE FROM D3572-5F)**

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WORK ORDER
NO. _____

RELEASED

07.06.01 *[Signature]*

D3572-3/-5 NOTES:

- 1) D3572-3 MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR PER QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6B)
- 2) D3572-5 MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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